Date:

Monday, 7/9/2007 11:46:47 AM

User:

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 10725 **Estimate Number**

P.O. Number

This Issue

: 4/4 : 7/9/2007

S.O. No. : 1/14

Prsht Rev. First Issue

: 33234

: MACHINED PARTS

Drawing Revision Material

Drawing Name

Part Number

Drawing Number

Project Number

Due Date

: D2652

· D2652 REV A : N/A

: BUSHING

:NW

: 7/20/2007

Qty:

400 Um:

Each

Written By

Previous Run

Checked & Approved By

Comment

02.06.13

Now machined in house.

NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

2.0

4.0

M303R0500

303 Round Bar 0.500"



Comment: Qty.:

HARDINGE

0.0578 f(s)/Unit Total:

23.1000 f(s)

Material:303 ss .500" Round Bar M 104 919

(M303R0500) Batch: 10535 4





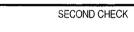
Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr 3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8





Comment: SECOND CHECK

5.0 PACKAGING 1

PACKAGING RESOURCE #



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 5740



Dart Aerospace Lt

W/O:		WORK ORDER CHANGES							
DATE	STEP		PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		14							
						n			
Part No	:	.	PAR #:	Fault Category:	NCR: Yes	No DOA	· 75) Date:	m2/20

QA: N/C Closed: ____ Date: __

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
,		Description of NC		Corrective Action Section B				
DATE	STEP Section A		Initial Chief Eng	Initial Action Description Sign &		Verification Section C	Approval Chief Eng	Approval QC Inspector
				•				
		*						:

NOTE: Date & initial all entries

Date:

Monday, 7/9/2007 11:46:47 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33350

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U A89.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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						-,		
		·						
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:		
			04.1	N/C Classe	J.	Data		

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC		Corrective Action Section B			A	Approval QC Inspector	
		Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Verification Section C	Approval Chief Eng			
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		4						÷	
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i.									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	333 5 0
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

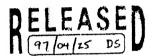
Inspection Dwg	: D2652 Re v	<i>γ</i> : Α				Pa	ge 1 of 1
FIRST ARTICLE INSPECTION CHECKLIST X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
0.600	+/-0.010	,600					
0.060	+/-0.005	261					
Ø0.305	-0.002/+0.000	.304					
Ø0.191	+0.005/-0.000	.1945					
Ø0.500	+/-0.010	.499					
0.030 x 20°	+/-0.010	1030 x 28	-				
R0.010	+0.010/-0.000	8,008					
						1.	
			130				
						1	
	7	·	·	<u> </u>			
Measured by:	19,	Audited by:	7.4.		Prototype App	oroval:	N/A
Date:	7/04/9	Date:	07/09	<u> 19</u> [Date:	
Rev Date Change Revised by Approved							

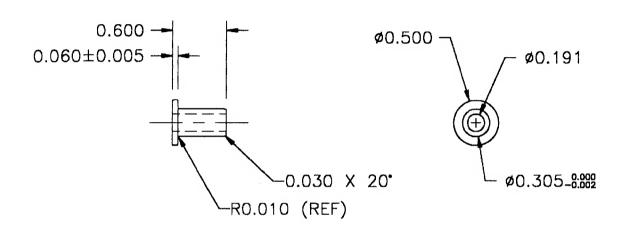
Meas	ured by:	29.	Audited by: 5, 5 "	Prototype Approval:	N/A
	Date: 6	7/04/9	Date: 07/09/19	Date:	
Rev	Date	Chánge		Revised	
Α	03.12.12	New Issue		KJ/RF 🗷	(
					()





DESIGN	DRAWN BY	DART AEROSPA	
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	1010Y	D2652	SHEET 1 OF 1
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTE PRINTO

SHOP COPY

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE